

Date: Wednesday, 6/28/2006 10:14:22 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 27711	
Estimate Number : 12462	
P.O. Number : NIA	Part Number : D35083
This Issue : 6/28/2006 S.O. No. : NIA	Drawing Number : D3508 PREL
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : SMALL /MED FAB	Drawing Revision : PREL
Previous Run : NIA	Material : NIA
Written By : <i>[Signature]</i> (COMMENT BELOW)	Due Date : 7/5/2006 Qty: 2 Um: Each
Checked & Approved By : <i>[Signature]</i> 06.06.28 n	
Comment : Est Rev: New Issue 06-06-20 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.7707 sf(s)/Unit Total : 1.5414 sf(s)
1010/1025/A21/6aA SHEET
(M1010S20GA)
Batch: *M100473*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3508
Dwg Rev: *Pre*
Prog Rev: *Pre*

2-Deburr if necessary

SAD 06:06:28 (2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:06:28 (2)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Julia 07.03 (2)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
1-Form on brake using DT8178 and DT8261 as per Dwg D3508
2-Form joggle as per Dwg D3508 Using DT8158

SB 06/07/04 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/07/04

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: WEARPLATE

Job Number: 27711

Part Number: D35083

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

06-07-18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5363

AR 06/07/19

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.19

Job Completion



Return to R
after completion
06.07.18

06.07.19

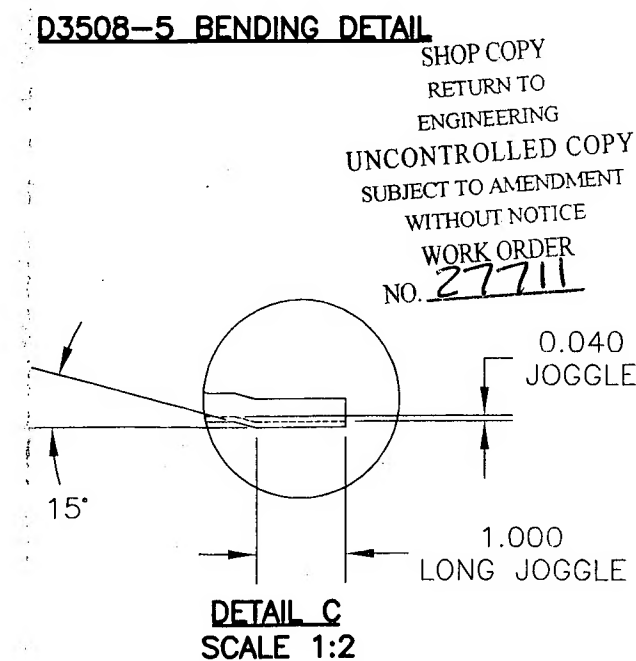
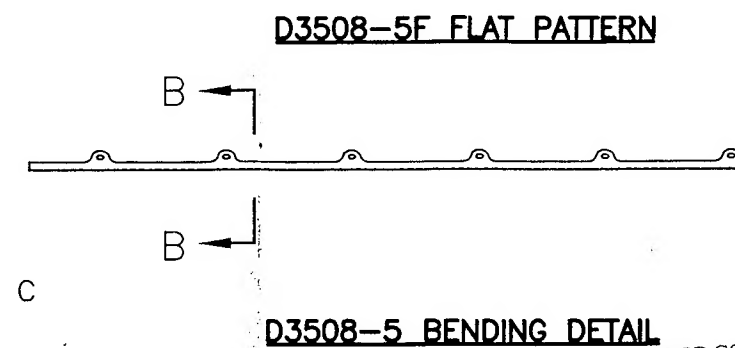
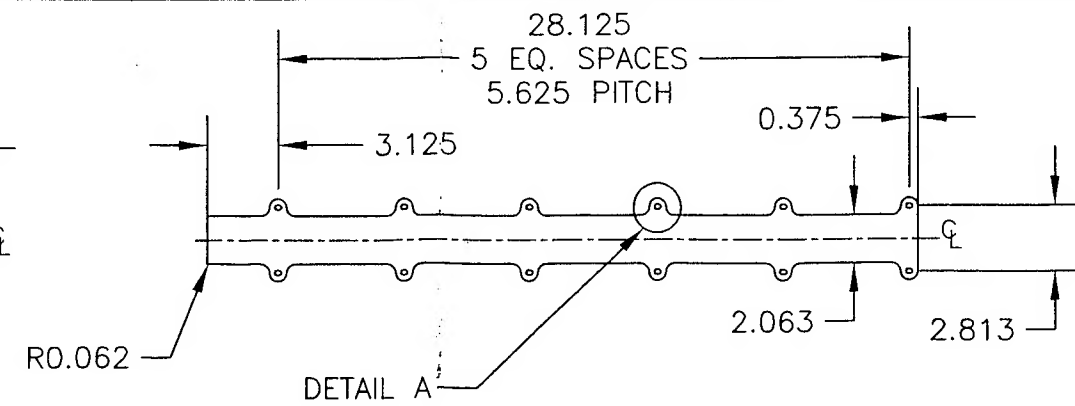
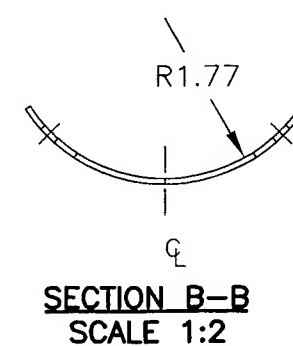
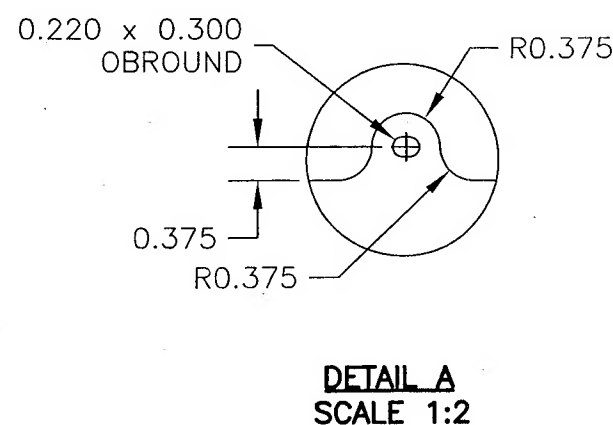
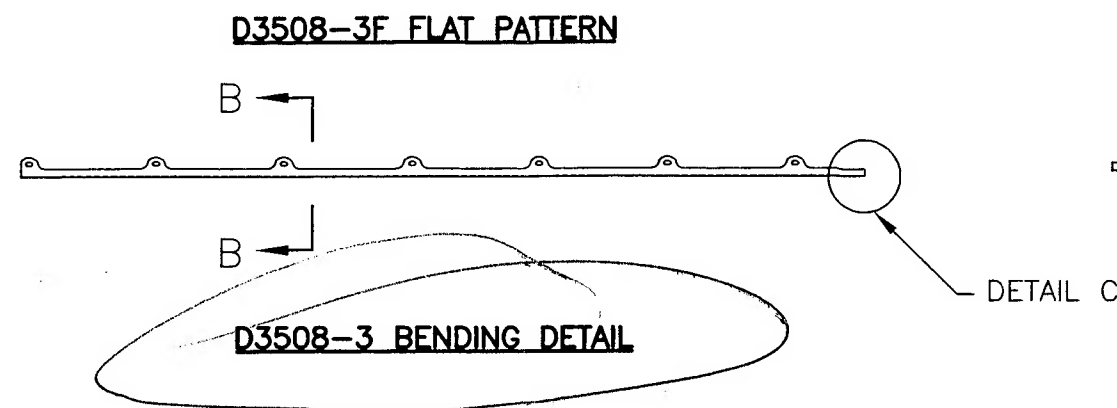
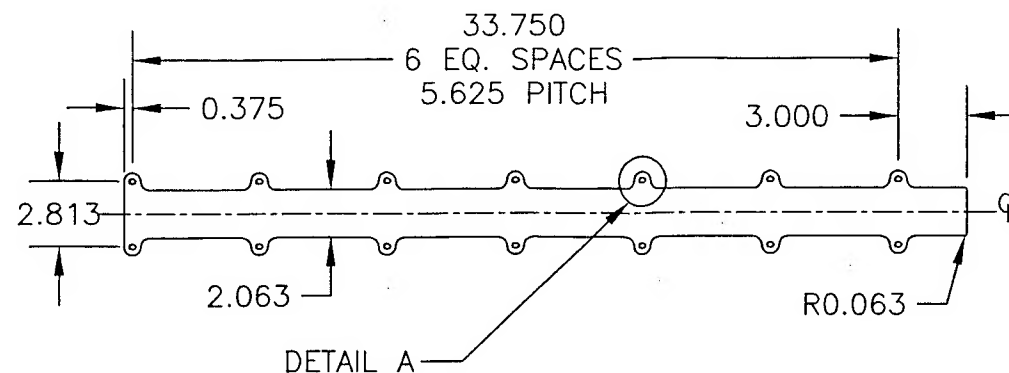
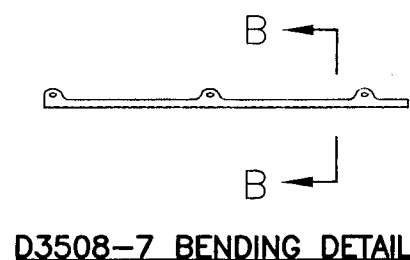
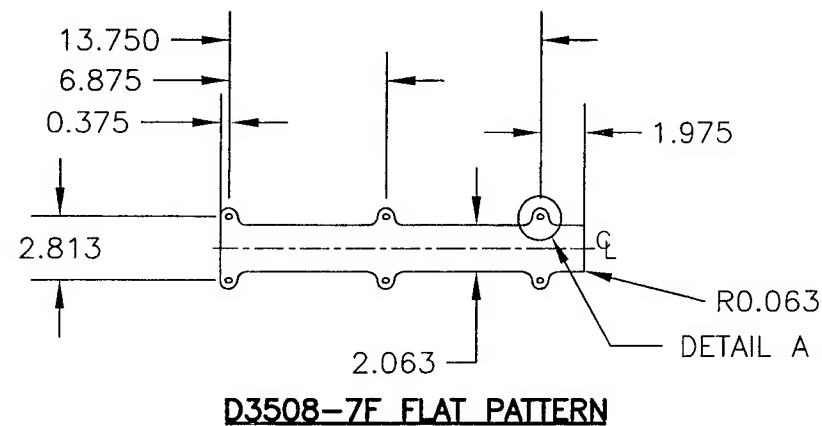
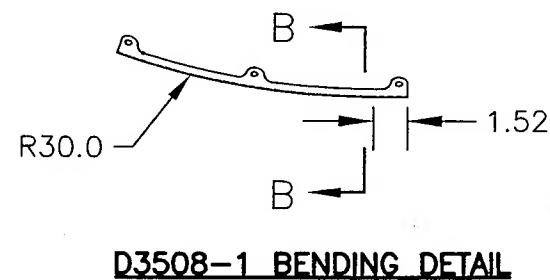
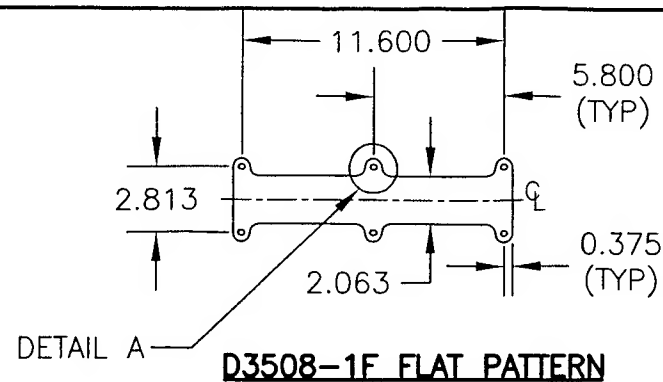
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries


QA: N/C Closed: _____ Date: _____



D3508-1/-3/-5/-7 WEARPLATE NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 20 GAUGE (0.040 THICK). (REF DART MATERIAL SPEC M1010-S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

PRELIMINARY ISSUE

A		06.04.21		NEW ISSUE	
DESIGN		DRAWN BY		 DART AEROSPACE USA, INC. PORT HADLOCK, WA	
PH		PH			
CHECKED		APPROVED		DRAWING NO. REV. A	
				D3508 SHEET 1 OF 1	
DATE		TITLE		SCALE	
06.04.21		WEARPLATE		1:1	

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M106473



SIDERURGICA DEL ORINOCO (SIDOR), C.A.

MATANZAS - VENEZUELA

CERTIFICADO DE CALIDAD / MILL TEST CERTIFICATE

PAGINA: 01-A

N° DE CERTIFICADO
04210437

ID: 28925

CS
LO
IL
ED
NT
EO

TECHINTRADE CORP.
2200 WEST LOOP SOUTH, SUITE 750
HOUSTON, TEXAS 77027.

DE
SH
SI
TP
I
NT
OO

MONTREAL, CANADA

ORDEN DE COMPRA - Purchase Ord. N° *
ORDEN DE VENTA - RN - Sidor Ord. N° SA98616 -07
DESPACHO - Shipper N°
FACTURA - Invoice N°
VEHICULO - Vehicle IDA

FECHA 01 09 04
HORA 11 11 04
LOTE: L0001

PRODUCTO
Product

PRIME NEWLY PRODUCED COLD
SAMUEL. SON & CO J15000 /

ROLLED STEEL COILS
TECHINTRADE S.O. 100000217

ASTM A 1008 CS TIPO-B

DIMENSIONES
Dimensions

COLOUR MARK

SIZE
0.0550

MIN X 48.000

TIPO DE
ANALISIS
Analysis Type

HEAT
PHYSICAL TEST

PHYSICAL TEST

CHEMICAL COMPOSITION - %

N° COLADA Heat N°	N° DE MUESTRA Sample Identification	TRACCION			DRZ	DOB	C	MN	P	S	SI	CU	AL	MO	NB	V	NI	CR	B
		ESF Y.P	ESF UTS	% AL	-1		-2	-2	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-4
		MPA	MPA	002P	HRB	GRAD													
		MIN.	MAX.																
		1.00	2.00	1.00			2						20						
					600		15	60	30	35	100	200	80	60	8	8	200	150	10
243097		214.00	312.00	40.00	490	OK	005	028	010	004	023	010	029	004	001	001	011	013	000
544031		215.00	336.00	38.00	500	OK	006	028	009	004	064	002	029	002	001	001	003	006	001
644146		187.00	274.00	38.00	580	OK	007	033	009	001	032	007	023	002	001	001	005	009	000

OBSERVACIONES / NOTE

C43748

SIDERURGICA DEL ORINOCO (SIDOR), C.A.
Gerencia de Gestión de Ordenes
as leasing agent

TECNICO DE ASEGURAMIENTO

THE RESULTS INDICATED IN THIS DOCUMENT HAVE BEEN VALIDATED BY ENR. LUIS RODRIGUEZ LABORATORY MANAGER